

Date: Thursday, 27/11/2008 2:23:39 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 206 A/B HIGH GEAR WEB
Job Number	: 43805	Part Number	: D26543
Estimate Number	: 10455	Drawing Number	: D2654 REV:E1
P.O. Number	:	Project Number	: N/A
This Issue	: 27/11/2008	Drawing Revision	: E1
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 10/12/2008
Previous Run	: 43120	Qty:	2
Written By	:	Um:	Each
Checked & Approved By	: <u>JLD 08.11.08</u>		
Comment	: Est Rev:D 99.02.04 Fixed typo, Changed procedure DM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
Comment:	Qty.: 1.0000 Each(s)/Unit	Total : 2.0000 Each(s)
Pick:	Qty	Part Number
	1	D2600-5
		Description
		Batch
		38589
		<i>D 08-12-08</i>
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1		
1-Cut D2600-5 to length as per Dwg D2654		
2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654		
3-Using the uni-bit, open holes to finish size as per Dwg D2654		
4-Deburr holes and ends		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		
Chemical Conversion Coat as per QSI 005 4.1		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 27/11/2008 2:23:40 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 43805

Part Number: D26543

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(2)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8-12-8

6.0 PACKAGING 1

PACKAGING RESOURCE #1



(2)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: L.G AUM

8-12-08

7.0 QC21

FINAL INSPECTION/W/O RELEASE



08/12/09 (2)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MR 08-12-08

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

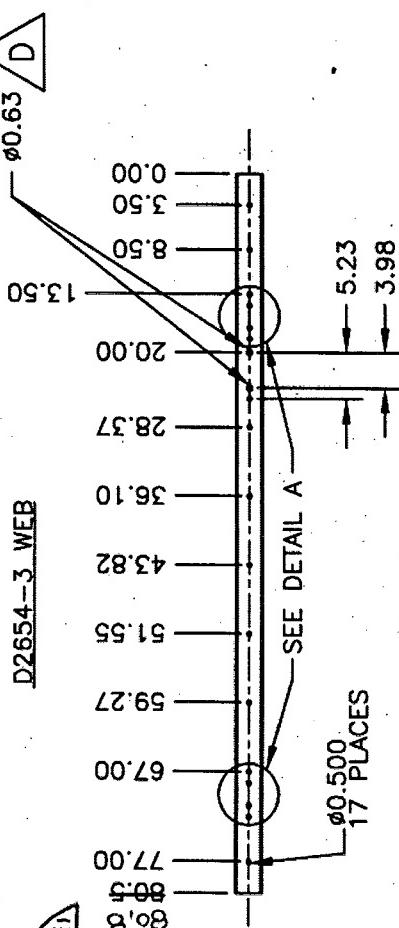
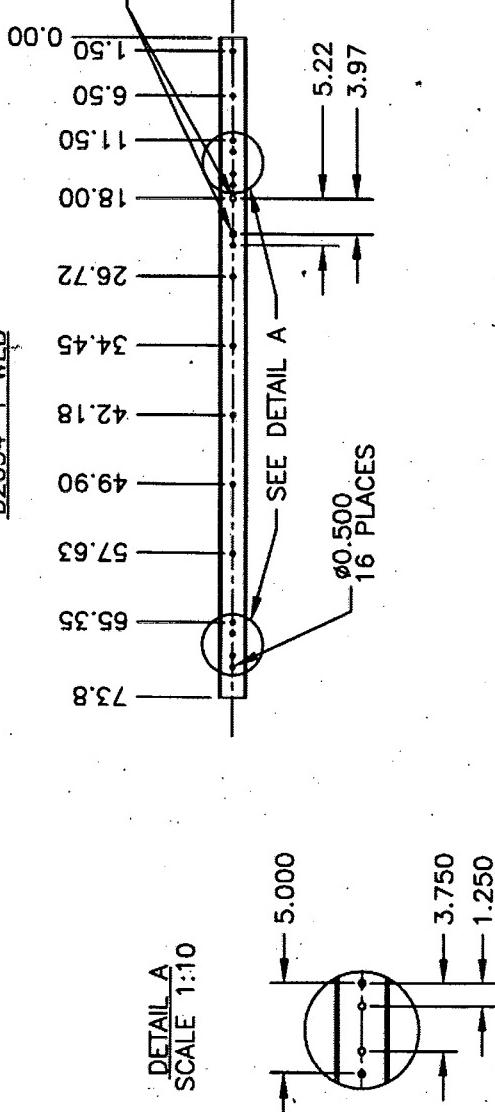
NOTE: Date & initial all entries

**DART**COPY/IS  
DRAFT

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D2654 REV. E SHEET 1 OF 2
DATE		TITLE WEB SCALE 1:20
04.05.26		
A	97.03.25	NEW ISSUE
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438
C	97.10.29	CHANGED HOLE PATTERN
D	98.01.15	GHW HOLES CHANGED TO Ø0.63
E	04.05.26	CHANGE LENGTHS, REFORMAT
E1	04.08.24	PER TOOLING; 80.8 WAS 80.5

**RELEASED**  
04.06.22

D2654-1 WEB

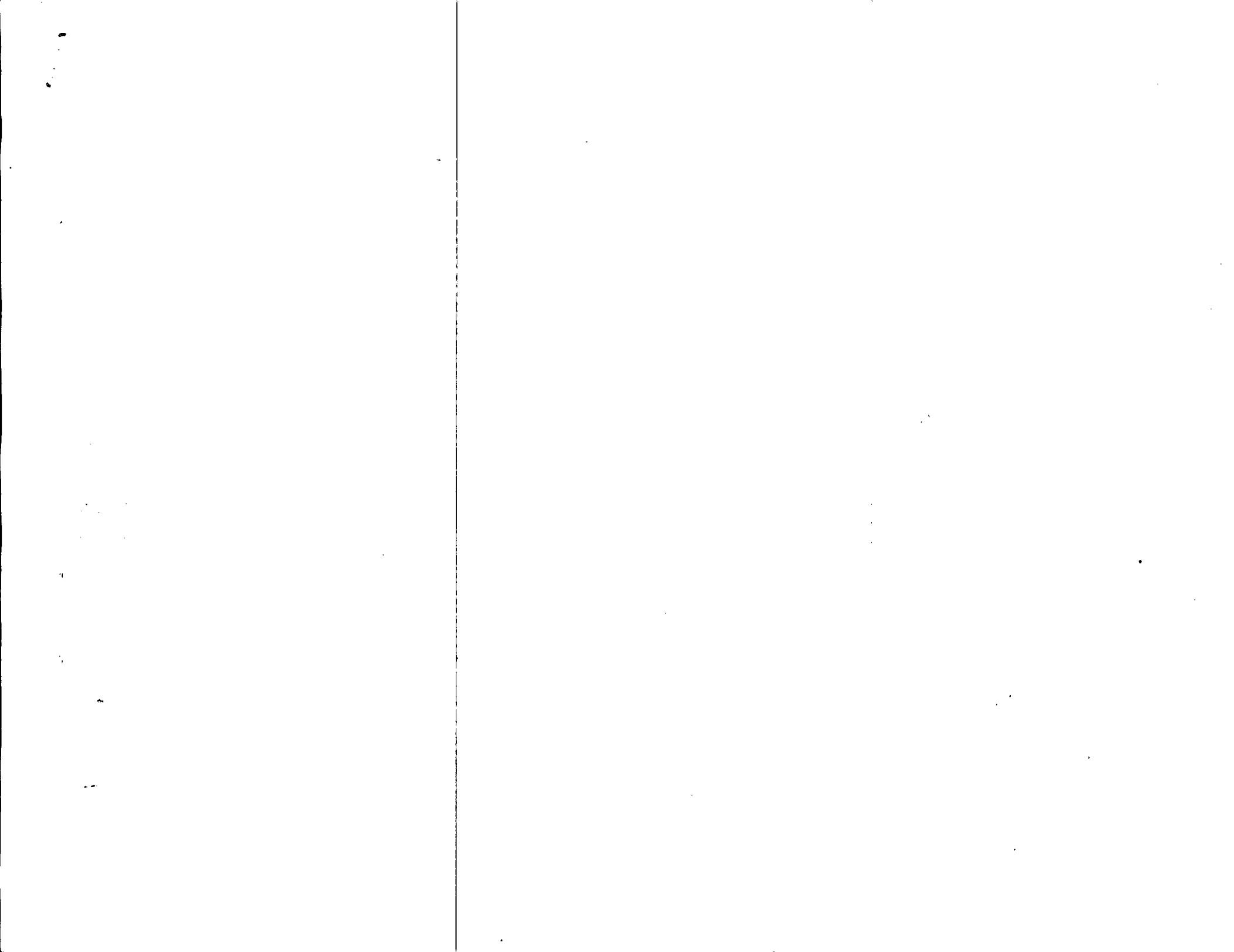


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NO. 4380

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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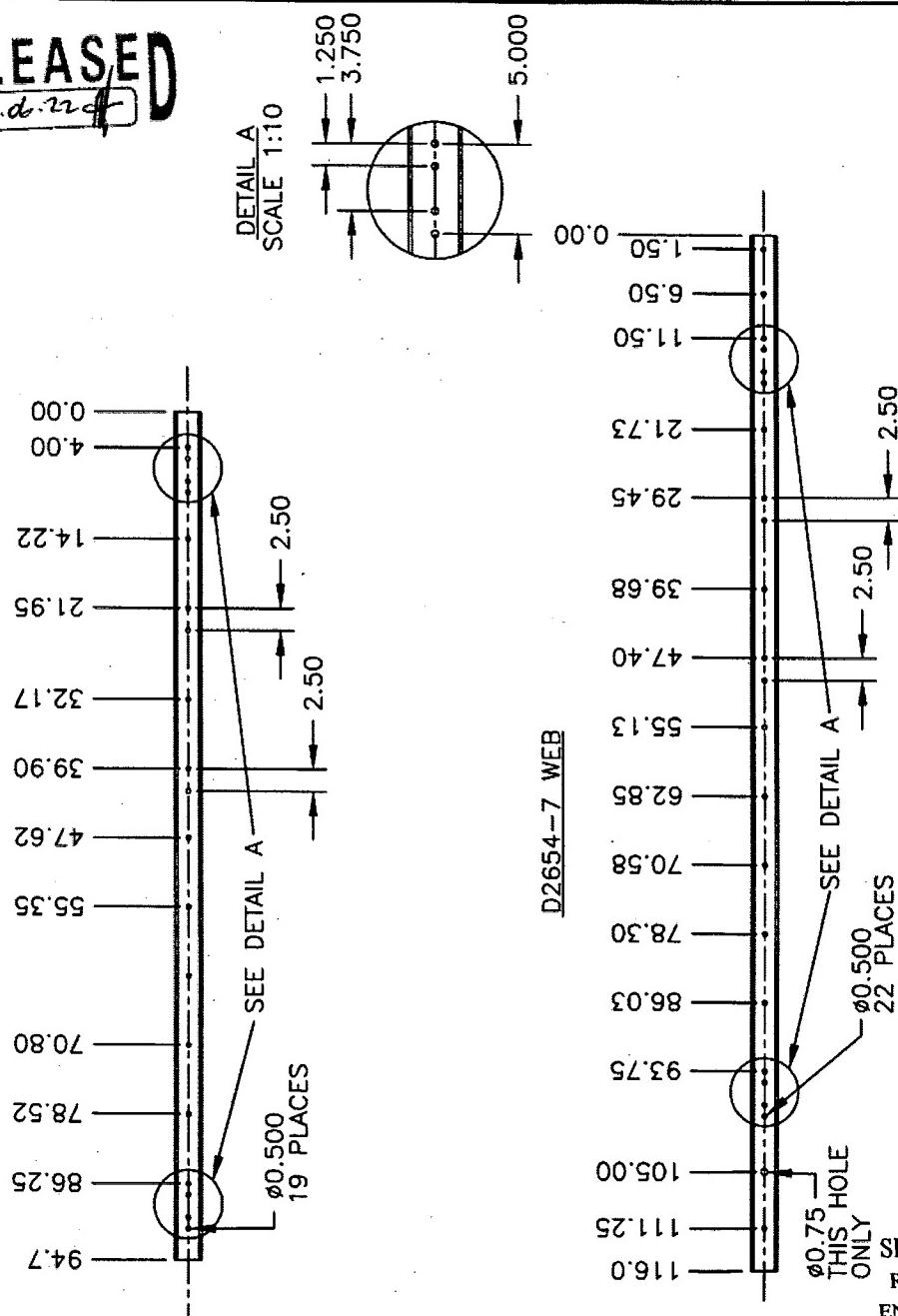
**DART**

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DATE		TITLE WEB SCALE 1:20

04.05.26

**RELEASED**  
04.06.22

D2654-5 WEB



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MAKE FROM D2600-7-125 EXTRUSION  
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